

Work Order ID 162563

Monday, June 05, 2017 9:32:18 AM

162563

Page 1

Item ID: D4182-1 Accept **DAS 13 9-89** ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Fitting, Quick Disconnect
 Start Date: 6/5/2017 Start Qty: 4.00 **16** ***4*** **JUN 12 2017** Cust Item ID:
 Required Date: 6/5/2017 Req'd Qty: 4.00 ***4*** Customer:

Reference: **DAS**
 Approvals: Process Plan: **21** **9-89** Date: **JUN 07 2017** Tooling: Date: Run Start ***NR1***
 QC: Date: SPC (Y/N): Date: Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
D4182	B

100	PURCHASING	0.00							DAS 13 9-89
100									
Purchasing	Memo	0.00							
Purchasing	Issue P/O: 36665								
	Purchase Part Number: P/N 6718K52								
	Supplier: MCMASTER CARR								
	Material release note is required.								

110	Receive & Inspect for Damage & Mat'l Certs	0.00							
110									
Packaging	Memo	0.08							
Packaging	Ensure material release note is attached								

16 SP17-6-15

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date : _____	Step #: _____	QTY Effective : _____		MRB (QSI042) Approval	
Description Work Order Deviation		Disposition			
				Completed By	
				Lead hand / Supervisor Approval Verification	
				QC / QA Coordinator Approval	
Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐		FAULT CATEGORY Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐			
OTHER : ☐					

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162563

Page 2

Item ID: D4182-1 Accept ***N900040100*** Setup Start ***NS1***
Revision ID: Stop ***NS2***
Item Name: Fitting, Quick Disconnect
Start Date: 6/5/2017 Start Qty: 4.00 ***4*** Cust Item ID:
Required Date: 6/5/2017 Req'd Qty: 4.00 ***4*** Customer:
Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120	QC6- All purchased or subcontracted products	0.00							
120									
QC	Memo	0.00							
Quality Control									
130	Identify as per dwg & Stock Location: STOP	0.00							
130									
Packaging	Memo	0.04							
Packaging									
140	QC21- Final Inspection - Work Order Release	0.00							
140									
QC	Memo	0.40							
Quality Control									

JUN 16 2017

JUN 19 2017

JUN 19 2017

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval		
Description Work Order Deviation				Disposition					
								Completed By JG	
								Lead hand / Supervisor Approval Verification	
								QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY							
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐				
Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐				
Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐				
Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐				
Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐				
Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐				
Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐				
Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐				
LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐				
Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐				
Past Expiry Date ☐	Manufacturing Process ☐								
Misidentified ☐	Past Due ☐	OTHER : ☐							

Picklist Print

Monday, June 05, 2017 9:32:16 AM

Page 1

Work Order ID: 162563

162563

Parent Item: D4182-1

D4182-1

Parent Item Name: Fitting, Quick Disconnect

Start Date: 6/5/2017

Required Date: 6/5/2017

Start Qty: 4.00

Required Qty: 4.00

Comments: IPP Rev:A 10.10.05 new issue verf:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
6718K52		Purchased	No			110	Each	0.0000	1				
6718K52									**				
Fitting, Quick Disconnect													

14
16 SP 17-6-15.

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE

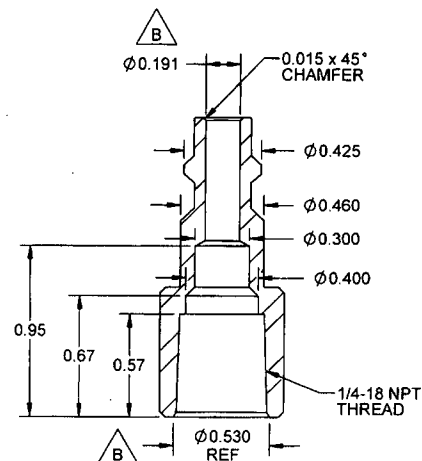
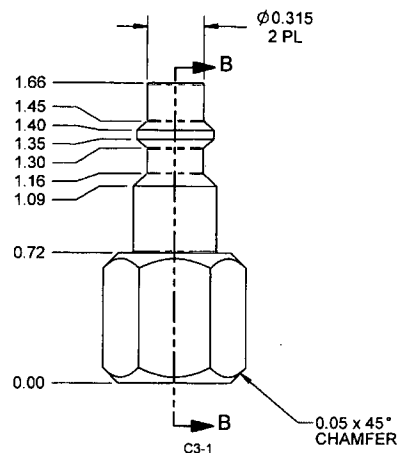
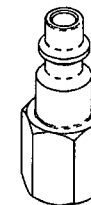


QA Closed: _____ Date: _____

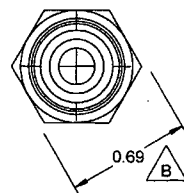
Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐																																																													
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Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐	Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐	Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐	Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐	Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐	Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐	Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐	Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐	LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐	Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐	Past Expiry Date ☐	Manufacturing Process ☐	OTHER : ☐			
Misidentified ☐	Past Due ☐																																																																

SPECIFICATION CONTROL DRAWING



SECTION B-B C6-1



D4182-1 FITTING, QUICK DISCONNECT

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER

NO 162563 MJS
170607

RELEASED
2011-06-30

NOTES:

- 1) MATERIAL: STAINLESS STEEL
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: PER QSI 044 6.1
- 7) WEIGHT: 0.07 lbs
- 8) POSSIBLE SUPPLIER: McMASTER CARR P/N 6718K52

B	0.191 WAS 0.201 (ZN D4-1); 0.57 WAS 0.45 (ZN C4-1); 0.69 WAS 0.82 (ZN B5-1)	RF	11.03.07
A	NEW ISSUE	RF	10.09.16
REV.	DESCRIPTION	BY	DATE
DESIGN	RF	DART AEROSPACE USA, INC.	
DRAWN	RF	PORT HADLOCK, WA	
CHECKED	RF	DRAWING NO.	REV. B
MFG. APPR.	RF	DSC-D4182	SHEET 1 OF 1
APPROVED	RF	TITLE	SCALE
DE APPR.	RF	FITTING	NTS
DATE	11.03.07	COPYRIGHT © 2010 BY DART AEROSPACE USA, INC. THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.	



Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
Tel: 613 632 9577
Fax: 613 632 1053

PURCHASE ORDER

Purchase Order ID PO36665

Purchase Order Date 6/12/2017

PO Print Date 6/12/2017

Page Number 1 of 6

Order From :
MCMASTER-CARR SUPPLY CO,
P.O. BOX 7690
CHICAGO, IL 60680-7690
US

VU-MCM001

Ship To : DART AEROSPACE LTD
1270 ABERDEEN
HAWKESBURY, ON K6A 1K7
CANADA

E-MAILED
JUN 12 2017

Contact Name		Buyer	Chantal Lavoie
Vendor Phone	330 995 5500	Customer POID	
		Customer Tax #	10127-2607
Ship To Contact		Terms	Net 10
Ship To Phone		Currency	USD
Ship Via:	Purolator ground ppd	FOB	FCA - (Free Carrier)
Ship Acct:			

Line Nbr	Reference Vendor Part Number Line Comments Delivery Comments	Description/ Mfg ID	Req Date/ Taxable Promise Date	CD	Req Qty/ Unit of Measure	PO Unit Price	Extended Price
	6718K52	Fitting, Quick Disconnect	6/14/2017 Yes 6/14/2017		16.00 Each	\$5.81	\$92.96
	AS PER DWG D4182 REV. B B162563						
						Line Total:	\$92.96
2	6047T33	Vinyl Marking Tape, Black	6/14/2017 Yes 6/14/2017	FN	108.00 Each	\$0.23	\$24.93
1 ROLL OF 108 FT						Line Total:	\$24.93
3	92198A111	Bolt	6/14/2017 Yes 6/14/2017	FN	25.00 Each	\$0.21	\$5.31

SP17-6-15

DA6
38
9-89

Note:

6/12/2017

200 Aurora Industrial Pkwy
Aurora OH 44202-8087
330-995-5500
cle.sales@mcmaster.com

Dart Aerospace Ltd
1270 Aberdeen St
Hawkesbury ON K6A 1K7
Canada

Purchase Order
PO36665
Order Placed By
Chantal Lavoie

McMaster-Carr Number
4488228-01

Page 1 of 1
06/12/2017

Line	Product	Ordered	Shipped
1	6718K52 303 Stainless Steel Industrial-Shape Air Hose Coupling Plug, 1/4 Coupling Size, 1/4 NPTF Female End	16 Each	16
2	6047T33 3M 471 Floor Marking Tape 1" Wide, Black, 108 Feet Long	1 Each	1
3	92198A111 18-8 Stainless Steel Hex Head Screw 1/4"-28 Thread Size, 1-1/2" Long, Partially Threaded, Packs of 25	1 Pack	1
4	7579A34 Round Nozzle, 1/16" Opening ID, 4" Long, for Dispensing Gun	20 Each	20
5	6641A41 Flexible Gasket Maker Sealant Loctite 598, 2.36 oz. Tube	15 Each	15
6	7510A653 Plastic Syringe with Luer Lock Tip, 0.34 oz. Capacity, Packs of 10	15 Packs	15
7	93980A170 Adhesive-Grip Female-Threaded Anchor for Concrete, Steel, 1/2"-13 Thread Size	12 Each	12
8	4289A34 Adjustable Length Deburring Tool with Three Blades, Jesse	8 Each	8
9	4289A29 Blade Holder for Heavy Duty Deburring Tool, Jesse	2 Each	2
10	4289A53 Deburring Blade for Hole Back Edge, Trade No. E-600, Jesse	10 Each	10
11	5155T28 Laboratory Tygon PVC Tubing for Chemicals 1/4" ID, 1/2" OD	120 Feet	120
12	53485K22 Push-on Brass Barbed Hose Fitting 1/4" ID, 7/16"-20 UNF 37 & 45 Degree Female Flared End, Packs of 5	3 Packs	3
13	50715K676 37 Degree Flared Fitting for Stainless Steel Tubing Straight Adapter for 1/4" Tube OD, 7/16"-20 UNF Male, Your Line 14	6 Each	6
14	9776K33 1" Wide x 75' Long Hook, Adhesive Back, Beige	1 Each	1

DAS
38
9-89

McMaster-Carr Supply Company
200 Aurora Industrial Pkwy
Aurora, OH 44202-8087 USA
Phone: 330-995-5500 Fax: 330-995-9600
E-Mail: cle.sales@mcmaster.com
Employer Identification Number (EIN): 36-1458720

Invoice: 34188797
Purchase Order: PO36665
Release:
McMaster-Carr Number: 4488228-01

ORIGINAL COMMERCIAL
INVOICE
CERTIFICATE OF ORIGIN

Ultimate Destination:
Dart Aerospace Ltd
1270 Aberdeen St
Hawkesbury ON K6A 1K7
Canada

Shipped: 12-Jun-2017
Shipper's Export Declaration (SED):
NO EEI 30.36

Intermediate Consignee:

Bill To:
Dart Aerospace Ltd
1270 Aberdeen St
Hawkesbury ON K6A 1K7
Canada

Tax Number:

Forwarding Agent:

Billing
Attention:
Shipping
Attention:
Contact:

Line	Description	Qty & Unit	Unit Price	Extension
1	6718K52 303 Stainless Steel Industrial-Shape Air Hose Coupling Plug, 1/4 Coupling Size, 1/4 NPTF Female End Country of Origin: United States Schedule B #: 848190 ECCN #: 2B999 NLR	16 EA	\$5.81	\$92.96
2	6047T33 3M 471 Floor Marking Tape 1" Wide, Black, 108 Feet Long Country of Origin: United States Schedule B #: 391910 ECCN #: EAR99 NLR	1 EA	\$24.93	\$24.93
3	92198A111 18-8 Stainless Steel Hex Head Screw 1/4"-28 Thread Size, 1-1/2" Long, Partially Threaded, Packs of 25 Country of Origin: Taiwan Schedule B #: 731815 ECCN #: EAR99 NLR	1 PK	\$5.31	\$5.31
4	7579A34 Round Nozzle, 1/16" Opening ID, 4" Long, for Dispensing Gun Country of Origin: United States Schedule B #: 846792 ECCN #: EAR99 NLR	20 EA	\$1.64	\$32.80
5	6641A41 Flexible Gasket Maker Sealant Loctite 598, 2.36 oz. Tube Country of Origin: United States Schedule B #: 321410 ECCN #: EAR99 NLR	15 EA	\$14.49	\$217.35

817-6-15

Your order is subject only to our terms and conditions, available at www.mcmaster.com or from our Sales Department.

Shipping Weight (in kgs): 13	Number of Packages: 1	Invoice Amounts:	Merchandise Amount: \$1,282.94 Canadian GST/HST: \$169.27 Shipping Charges: \$19.13 Total (In USD): \$1,471.34
Package Dimensions: 44 X 44 X 32 CM = .063 CUBIC M		Payment Terms: 2% discount on merchandise only if paid within 10 days, net 30 days	
Authorized Signature: <i>Sarah Weinberg</i>	Date: 12-Jun-2017	Remit payment to: (by mail) McMaster-Carr Supply Company PO Box 7690 Chicago, IL 60680-7690 USA	(by wire transfer) Bank of America 222 Broadway New York, NY 10038 Account 86666-02021 SWIFT BOFAUS3N
Name: Sarah Weinberg	Title: Operations Mgr.		DAB 38 9-89

McMaster-Carr Supply Company
 200 Aurora Industrial Pkwy
 Aurora, OH 44202-8087 USA
 Phone: 330-995-5500 Fax: 330-995-9600
 E-Mail: cle.sales@mcmaster.com
 Employer Identification Number (EIN): 36-1458720

Invoice: 34188797
 Purchase Order: PO36665
 Release:
 McMaster-Carr Number: 4488228-01

ORIGINAL COMMERCIAL
INVOICE
 CERTIFICATE OF ORIGIN

Line	Description	Qty & Unit	Unit Price	Extension
6	7510A653 Plastic Syringe with Luer Lock Tip, 0.34 oz. Capacity, Packs of 10 Country of Origin: United States Schedule B #: 392690 ECCN #: EAR99 NLR	15 PK	\$8.39	\$125.85
7	93980A170 Adhesive-Grip Female-Threaded Anchor for Concrete, Steel, 1/2"-13 Thread Size Country of Origin: Peoples Republic of China Schedule B #: 731815 ECCN #: EAR99 NLR	12 EA	\$4.34	\$52.08
8	4289A34 Adjustable Length Deburring Tool with Three Blades, Jesse Country of Origin: Israel Schedule B #: 820559 ECCN #: EAR99 NLR	8 EA	\$10.83	\$86.64
9	4289A29 Blade Holder for Heavy Duty Deburring Tool, Jesse Country of Origin: Israel Schedule B #: 846610 ECCN #: EAR99 NLR	2 EA	\$5.79	\$11.58
10	4289A53 Deburring Blade for Hole Back Edge, Trade No. E-600, Jesse Country of Origin: Israel Schedule B #: 820790 ECCN #: EAR99 NLR	10 EA	\$3.24	\$32.40
11	5155T28 Laboratory Tygon PVC Tubing for Chemicals 1/4" ID, 1/2" OD Country of Origin: United States Schedule B #: 391732 ECCN #: EAR99 NLR	120 FT	\$3.52	\$422.40
12	53485K22 Push-on Brass Barbed Hose Fitting 1/4" ID, 7/16"-20 UNF 37 & 45 Degree Female Flared End, Packs of 5 Country of Origin: United States Schedule B #: 741220 ECCN #: EAR99 NLR	3 PK	\$12.81	\$38.43
13	50715K676 37 Degree Flared Fitting for Stainless Steel Tubing Straight Adapter for 1/4" Tube OD, 7/16"-20 UNF Male, Your Line 14 Country of Origin: United States Schedule B #: 730729 ECCN #: 2B999 NLR	6 EA	\$8.27	\$49.62
14	9776K33 1" Wide x 75' Long Hook, Adhesive Back, Beige Country of Origin: United States Schedule B #: 590699 ECCN #: EAR99 NLR	1 EA	\$90.59	\$90.59
	NOTE These items are controlled by the U.S. Government and authorized for export only to the country of ultimate destination for use by the ultimate consignee or end-user(s) herein identified. They may not be resold, transferred, or otherwise disposed of, to any other country or to any person other than the authorized ultimate consignee or end-user(s), either in their original form or after being incorporated into other items, without first obtaining approval from the U.S. government or as otherwise authorized by U.S. law and regulations.			
	NOTE Tracking number(s) for this shipment: CPK005533848			

Number of Packages: 1

Page 2 of 2